



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18660-1
Job Sheet 189211



Part No: RBT18660-1

Job Qty: ~~6~~ pcs

Part Name: Quill



8 pcs
DAG
21
9-08

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 3/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18660 Rev.1 IPP Rev. A 19.01.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	6 pcs	3/1/19	3/1/19	0.00	6.00	SL-154 - 1	19/02/07
120	QC 2	6 pcs	3/1/19	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	19/02/07
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Container No: S151639



Part: RBT18660-1

Job No: 189211

Serial No/Batch: S151639

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/19

130	QC 8	6 pcs	3/1/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.F 19-02-09
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
150	Outsource - 4 - Anodize	6 pcs	3/1/19		GRO002-VC	15 C219-02-11
160	Packaging 2-1 - Receive - B4B	6 pcs	3/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
		8 pcs Dp			Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	Dp FEB 20 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	6 pcs	3/1/19	0.00 0.00	QC 6 - 38	

				QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	FEB 21 2019 58
				QC 6 - 61	9-89
180	Packaging 3-1 - Stock - B4B	6 pcs	3/1/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	6 pcs	3/1/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per DWG. FC598 FOLIO REV: _____ DWG REV: _____ 2-
 Descriptions: Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

150 - Outsource process-Anodize per QSI017 4.1.10.1) - -Issue P/O to ATG : PO 04270 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.875	6061-T6 Round Bar .875"	1.4700 ft (.245 ea)	110-SL-154 - 1	5025755

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M6061T6R0.875	1	19	0

Part Specifications
Specifications could not be found.

Plex 1/28/19 8:14 AM Dart.Hadley.Shannon



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RBT18660-1
Job Sheet 189211



Part No: RBT18660-1

Job Qty: 6 ea

Part Name: Quill



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 3/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 12244 ship 18 March*

Note: DWG RBT18660 Rev.1 IPP Rev. A 19.01.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/1/19	3/1/19	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	6 pcs	3/1/19	3/1/19	0.00	6.00	SL-154		
112	QC	6 pcs	3/1/19	3/1/19	0.00	0.00	QC2 Machining-2		
114	Mill Conv	6 pcs	3/1/19	3/1/19	0.00	2.00	Conv Mill 1		
120	QC	6 pcs	3/1/19	3/1/19	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs	3/1/19	3/1/19	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs	3/1/19	3/1/19			GRO002-VC	15	
160	Packaging	6 pcs	3/1/19	3/1/19	0.00	0.00	Packaging2		
170	QC	6 pcs	3/1/19	3/1/19	0.00	0.00	QC6		
180	Packaging	6 pcs	3/1/19	3/1/19	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea	3/1/19	3/1/19	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB *CS98* FOLIO REV: *DAS* DWG REV: *45 19-01-23* 2-Debur
 Descriptions: ~~144 - 1-Machine as per DWG. 2-Debur~~
 120 - Engrave T/N Using Marktronic engraver as per DWG.
 150 - Issue P/O to ATG : PO *RED* -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.875	6061-T6 Round Bar .875"	1.4700 ft (.245 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.875	1	19	0

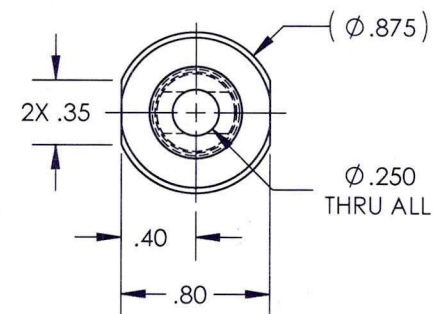
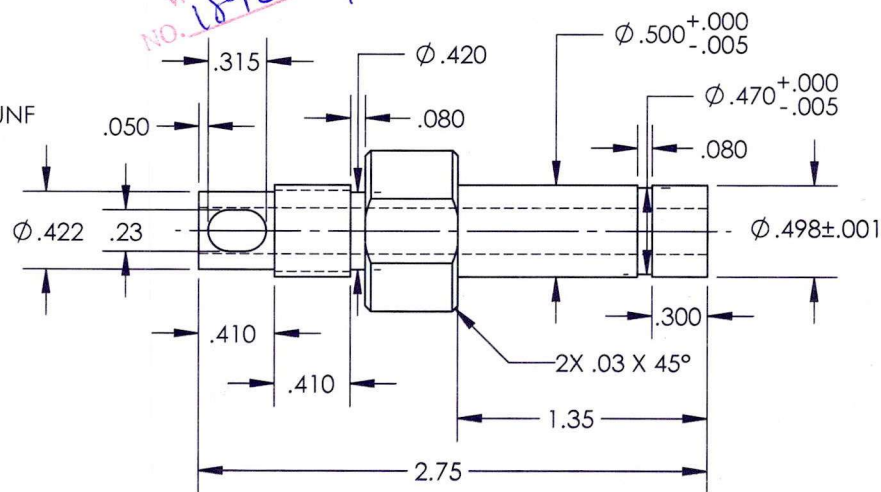
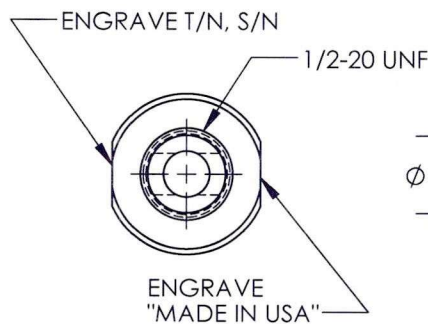
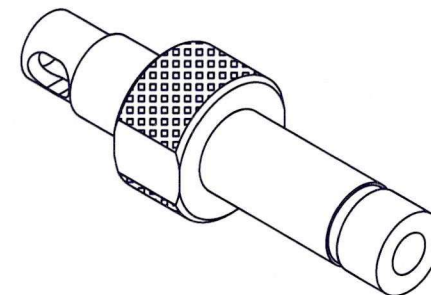
Part Specifications

Specifications could not be found.

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189211 MLC5
1901-21



(-1)
QUILL

DART AEROSPACE	
TITLE TAIL ROTOR DRAIN TOOL	
DWG NO. RBT18660-1	REV 1
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P Walbrick</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	RED ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL MD500
SCALE 1:1	DATE 2/17/2015
SHEET 2 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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CANADA
TEL.: 1 813 632-5208
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S151639



Part: RBT18660-1

Job No: 189211

Serial No/Batch: S151639

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 02/07/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042570



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042570
PO Date: 2/11/19
Due Date: 2/15/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: ** Need for Feb.15, please confirm if ok **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189027	RBT18632-1	Cup Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH PO: -- ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Material type; - Certificate of Conformity is required	Firmed -	X10 DP	2/15/19	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
2	189028	RBT18632-11	Press Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH PO: -- ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Material type; - Certificate of Conformity is required	Firmed -	X10 DP	2/15/19	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00



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PURCHASE ORDER PO042570



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189109	RB H4749-1	Drain Hose Body (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech: PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed - X17	-	2/15/19	17 pcs	0 pcs	17 pcs	\$3.2432432/pcs	\$55.14
4	189211	RBT18660-1	Quill Outsource process- Anodize per QSI017 4.1.10.1) - -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed - X8	-	2/15/19	8 pcs	0 pcs	8 pcs	\$3.2432432/pcs	\$25.95
5	189805	RBE703A95- 0520-01-1	Quill Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) - Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed - X12	-	2/15/19	12 pcs	0 pcs	12 pcs	\$3.2432432/pcs	\$38.92
Grand Total:											\$240.00



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PURCHASE ORDER

PO042570



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/12/19 9:16 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016765-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016765 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Feb-2019		Aman		PO042570				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18632-1 Rev.	RBT18632-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
2	RBT18632-11 Rev.	RBT18632-11 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
3	RB H4749-1 Rev.	RB H4749-1 01-ANO-RED [ANODIZE RED] IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	17	17	0	0	0
4	RBT18660-1 Rev.	RBT18660-1 01-ANO-RED [ANODIZE RED] IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
5	RBE703A95-0520-01-1 Rev.	RBE703A95-0520-01-1 01-ANO-RED [ANODIZE RED] ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	12	12	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.